

# Work Order ID 107070

**\*107070\***

Page 1

September-18-13 11:35:15 AM

Item ID: D4155-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

HAAS

Stop **\*NS2\***

Item Name: Bar

Start Date: 9/18/13

Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 9/27/13

Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4155

E

100

0.00

**\*100\***

Cold Saw

Hyd Mech

Memo

Cut blanks at 92.00"

(EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D4154-041)

0.00

DR/B.A  
13/09/23

20 Ø

110

0.00

**\*110\***

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: AA

DWG REV: E

0.00

B.A 13/09/27

DAS  
08  
9-89

2-Deburr as required

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**\*107070\***

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Item ID: D4155-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bar  
Start Date: 9/18/13 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 9/27/13 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		13/09/27					DAS 08 9-89
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				20			13-9-30
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>W14001</u>  Memo	0.00  0.00				20		13-09-30	MAL

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Item ID: D4155-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bar

Start Date: 9/18/13

Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 9/27/13

Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

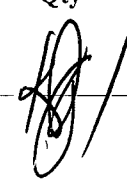
**\*150\***

QC

Memo

0.00

Quality Control

 / PL 13-09-30

PL 13-09-30

# Picklist Print

September-18-13 11:35:15 AM

Page 1

Work Order ID: 107070

Parent Item: D4155-1

Parent Item Name: Bar

Start Date: 9/18/13

Required Date: 9/27/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC  
revB DD verf:EC

IPP Rev:B 11.04.14 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 304 BAR .250 x .500		Purchased	No			100	f	423.3463	7.6333	160.70105			

Location

Loc Qty

Loc Code

MAT049

423.3463

124518

28.365

m126151

3.5683

m126378

391.413

155.00

DR/B.A  
13/09/23



1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240  
REF. DART SPEC. M304B0.250X0.500

2) FINISH : NONE

3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS : INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX


6) IDENTIFICATION : NONE

7) WEIGHT : 2.98 lbs

8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING.

Mo 107070

RELEASED  
2013-08-13  
wmp

E	DIMENSION DATUM ON OPPOSITE END OF PART; 92.00 WAS 91.59. REF CIR12-10	SFM	13.02.20
D	REDESIGNED WITH SHORTER CUTOUTS. NOTE 8 ADDED. (PAR 12-213); 0.18 WAS 0.13	AJS	12.08.07
C	REMOVED TOOLING HOLE; ADD CUT OUT PROFILE (ZN 58-1 & 57-1); 2 DEC TOLERANCE (D1-1 & 1-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS. MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4155	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	13.02.20	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PREPARED AND PROPRIETARY AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 107070
<b>Description:</b> BAR	<b>Part Number:</b> D4155-1
<b>Inspection Dwg:</b> D4155 <b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.18	+/-0.030	0.182	✓		Vern	GA-01
0.50	+/-0.030	0.495	✓		"	"
4.00	+/-0.030	4.015	✓		"	"
1.75	+/-0.030	1.760	✓		"	"
0.200	+/-0.010	0.197	✓		"	"
0.98	+/-0.030	0.972	✓		"	"
4.05	+/-0.030	4.050	✓		"	"
9.05	+/-0.030	9.030	✓		Tape	GA-12
14.05	+/-0.030	14.030	✓		"	"
25.05	+/-0.030	25.030	✓		"	"
30.55	+/-0.030	30.530	✓		"	"
47.34	+/-0.030	47.320	✓		"	"
61.34	+/-0.030	61.320	✓		"	"
81.34	+/-0.030	81.320	✓		"	"
86.84	+/-0.030	86.820	✓		"	"

<b>Measured by:</b> J.A. (DAS 08 9-89)	<b>Audited by:</b> V	<b>Preliminary Approval:</b>
<b>Date:</b> 13/09/27	<b>Date:</b> 13-9-30	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15